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D3914-041
Job Sheet 193615



Part No: D3914-041

Job Qty: 1 pcs

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/17/19

Job Tracking No:

Due Date: 5/20/19

Created By: Dara Macdonald

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 2, D3914 REV D SHEETS 1,2,3 IPP Rev:A new issue DD 10.03.19 verified by:EC
IPP Rev:B as per dwg revB DD 10.08.18 verified by:EC IPP Rev:C 13.03.14 AS PER DWG REV.pc1 DD
VERF:JLM IPP REV:D 13.06.21 DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	5/20/19		0.00	6.67	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
110	QC 9	1 pcs	5/20/19		0.00	0.00	Large Fab - 9		
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		DAS
							QC 9 - 50		43
120	QC 5	1 pcs	5/20/19		0.00	0.00	QC 9 - 9		9-39
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		DAS
							QC 5 - 43		43
							QC 5 - 49		9-39
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

130 Powdercoat - 4 Black Sand - B4B M138940 SHEET: 8-45 OUTSIDE FINISH 9-15	1 pcs	5/20/19	0.00 0.40	QC 5 - 9				
				QC 5 - 50				
				QC 5 - 30				
				QC 5 - 40				
				Powdercoat - 1 - B4B				
135 QC 3	1 pcs	5/20/19	0.00 0.00	Powdercoat - 2 - B4B				
				Powdercoat - 3 - B4B				
				Powdercoat - 4 - B4B				
				QC 3 - 10				
				QC 3 - 13				
				QC 3 - 15				
				QC 3 - 17				
				QC 3 - 18				
				QC 3 - 2				
				QC 3 - 28				
				QC 3 - 3				
				QC 3 - 30				
				QC 3 - 34				
				QC 3 - 36				
				QC 3 - 41				
				QC 3 - 51				
				QC 3 - 58				
				QC 3 - 59				
				QC 3 - 68				
				QC 3 - 9				
				QC 3 - 40				
				QC 3 - 19				
				Handfinish - 3 - 1 - B4B				
				Handfinish - 3 - 2 - B4B				
				Handfinish - 3 - 3 - B4B				
				Handfinish - 3 - 4 - B4B				
				Handfinish - 3 - 5 - B4B				
140 Handfinish - 3-1- WingWalk-B4B	1 pcs	5/20/19	0.00 0.80	QC 3 - 10				
				QC 3 - 13				
				QC 3 - 15				
				QC 3 - 17				
				QC 3 - 18				
150 QC 3	1 pcs	5/20/19	0.00 0.00	QC 3 - 2				
				QC 3 - 28				
				QC 3 - 3				
				QC 3 - 30				
				QC 3 - 34				
				QC 3 - 36				
				QC 3 - 41				
				QC 3 - 51				
				QC 3 - 58				
				QC 3 - 59				
				QC 3 - 68				
				QC 3 - 9				
				QC 3 - 40				
				QC 3 - 19				
				Packaging 3 - 1 - B4B				
				Packaging 3 - 2 - B4B				
				Packaging 3 - 3 - B4B				
				Packaging 3 - 4 - B4B				
				160 Packaging 3-1 - Stock - B4B	1 pcs	5/20/19	0.00 0.00	QC 3 - 10
								QC 3 - 13
								QC 3 - 15
								QC 3 - 17
								QC 3 - 18

					Packaging 3 - 5 - B4B						
					Packaging 3 - 6 - B4B						
					Packaging 3 - 7 - B4B						
					Packaging 3 - 8 - B4B						
					Packaging 3 - 9 - B4B						
					Packaging 3 - 10 - B4B						
					Packaging 3 - 11 - B4B						
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					Packaging 3 - 14 - B4B						
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					Packaging 3 - 32 - B4B						
					Packaging 3 - 33 - B4B						
					Packaging 3 - 34 - B4B						
					Packaging 3 - 35 - B4B						
					Packaging 3 - 36 - B4B	DAS 21 9-01					
					170 QC 21 - SA	1 pcs	5/20/19	0.00 0.00	QC 21 - SA - 21	DAS 21 9-01	MAY 23 2019
									QC 21 - SA - 70		
									QC 21 - SA - 53		
					Part Op 100 - (Weld per dwg A/R S.S. rod Batch: _____ - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld Descriptions: hinge (3) and Mounting brackets as per dwg D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on						

Plex 4/17/19 10:18 AM Dart.Macdonald.Dara

basket as per dwg D3914 ***Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh***

110 - QC9- Inspect visual per QSI004- Fusion Welds

120 - QC5- Inspect part completeness to step on W/O

130 - Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 *** mask sides of hinge prior to powdercoat***

135 - QC3- Inspect Part Finish

140 - Wing Walk as per dwg QSI005 4.4 Batch _____ 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

150 - QC3- Inspect Part Finish

160 - Identify as per dwg & Stock Location: _____

170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5178393
D3914-1	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5178172
D3914-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5170097
D4016-3	Hinge Half, Lid	3 pcs (3 ea)	100-Large Fab - Basket - 1	5110937
D4018-5	Rib	9 pcs (9 ea)	100-Large Fab - Basket - 1	5172268
D4020-5	Mesh (350 Basket Long, Lid)	1 pcs (1 ea)	100-Large Fab - Basket - 1	5168996
D4021-3	Data Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	5172001
D4035-043	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea)	100-Large Fab - Basket - 1	5177490

069715

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	27	0
	D3914-1	2	2	0
	D3914-7	2	10	0
	D4016-3	3	72	0
	D4018-5	9	52	0
	D4020-5	1	5	0
	D4021-3	1	49	0
	D4035-043	2	6	0

Part Specifications

Specifications could not be found.



Container No: S179769



Part: D3914-041

Job No: 193615

Serial No/Batch: S179769

Revision: A/D

Inspector:

Exp Date:

Instructions: Various STC's

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CANADA

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Date: 05/09/19